

Shp today

Work Order ID 68274



Monday, April 11, 2011 11:52:43 AM

Item ID: D3654-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Doubler					
Start Date: 4/11/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 4/11/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>u</u>	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3654	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3654 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								

B11-4-11

②

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B11-4-11

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

8 n 10414

④2

Work Order ID 68274

Page 2

Monday, April 11, 2011 11:52:43 AM

Item ID: D3654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>18V</u>	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

11/4/11

MS
11-04-11

Picklist Print

Monday, April 11, 2011 11:52:40 AM

Page 1

Work Order ID: 68274



Parent Item: D3654-1



Parent Item Name: Doubler

Start Date: 4/11/2011

Required Date: 4/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-10-29 DD verified by: EC
 IPP Rev:B ecn1162 08-04-02 DD verified by:ec
 IPP Rev:C 08-09-17 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

248.0000

0.35

0.736842



B11-4-11

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

248

117275

248

117275

②

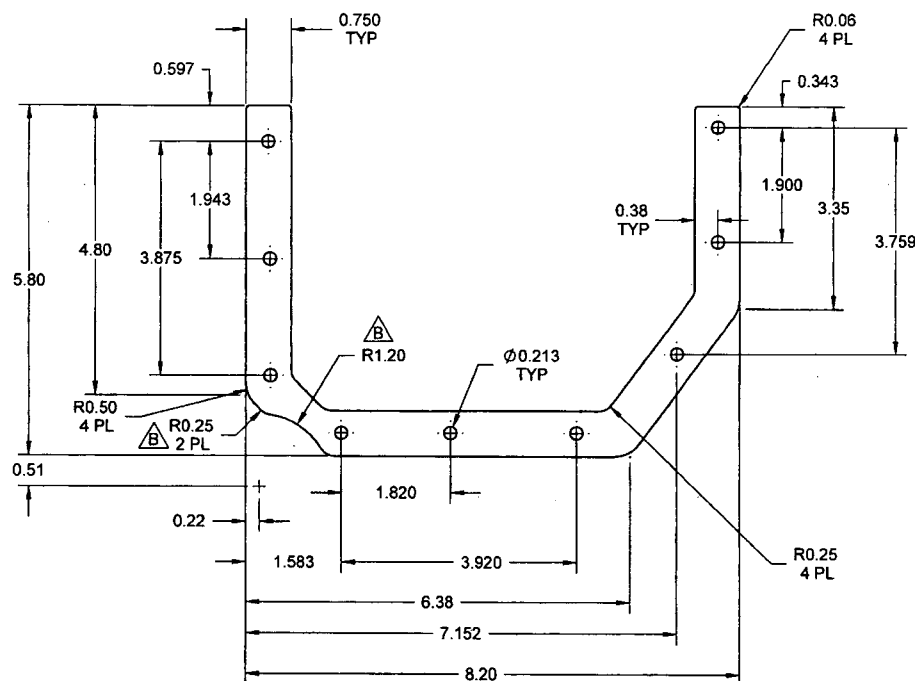
DART AEROSPACE LTD		Work Order: 68274
Description: Doubler		Part Number: D3654-1
Inspection Dwg: D3654 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.213	+0.005/-0.001	.213	P		V RB62	
0.750	+/-0.010	.756	X		V	
0.597	+/-0.010	.591	X		V	
1.943	+/-0.010	1.940	X		V	
3.875	+/-0.010	3.873	X		V	
4.80	+/-0.030	4.80	X		V	
5.80	+/-0.030	5.802	X		V	
1.583	+/-0.010	1.581	X		V	
1.820	+/-0.010	1.818	X		V	
3.920	+/-0.010	3.922	X		V	
6.38	+/-0.030	6.38	X		V	
7.152	+/-0.010	7.152	X		V	
8.20	+/-0.030	8.204	X		V	
0.343	+/-0.010	.345	X		V	
1.900	+/-0.010	1.901	X		V	
3.35	+/-0.030	3.35	X		V	
3.759	+/-0.010	3.759	X		V	
0.38	+/-0.030	.381	X		V	
0.063	+/-0.010	.058	X		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-4-11	Date: 11/04/11	Date:

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.12.17	Dimensions updated per Dwg Rev B	KJ	
C	11.01.17	Dwg Rev updated to B	KJ	M



D3654-1 DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

B	ADD R1.20 & R0.25 (ZN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5019 (ZN A6); REFORMATTED DRAWING TO CURRENT STANDARD	RF	08.09.11
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D3654	
CHECKED		REV. B SHEET 1 OF 1	
MFG. APPR.		TITLE DOUBLER	
APPROVED		SCALE NTS	
DE APPR.		DATE 08.09.11	
COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			